

Work Order ID 128944

Tuesday, January 27, 2015 7:54:56 AM

128944

Page 1

Item ID: D3015-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock Nut

Start Date: 1/27/15 Start Qty: 50.00

50

Cust Item ID:

Required Date: 1/27/15 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1501-29 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3015	C								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 27306

Description: SS locknut with nylon insert

Possible Supplier: Acklands P/N: PFSLNNC14S1

Material release note required

CX 15/02/02 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

100x 2015-02-5

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

100DAS
38
9-89

FEB 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128944***128944***

Page 2

Tuesday, January 27, 2015 7:54:56 AM

Item ID: D3015-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lock Nut

Start Date: 1/27/15

Start Qty: 50.00

50

Cust Item ID:

Required Date: 1/27/15

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

stop

0.00

130

Packaging

Memo

0.00

Packaging

100DWG
27
0.00

FEB 09 2015

140

QC21 - Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 1502 ORmf 15-29

DQA: _____ Date: _____



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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

Page 1

Tuesday, January 27, 2015 7:54:56 AM

Work Order ID: 128944

128944

Parent Item: D3015-1

D3015-1

Parent Item Name: Lock Nut

Start Date: 1/27/15

Required Date: 1/27/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A 14.05.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PFS-LNNC14S

Purchased

No

Each

0.0000

PFS-I NNC14S

SS Locknut

50/001

100 x SP15-02-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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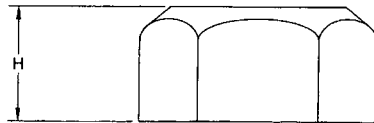
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SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000



NOTES:

- 1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

128944 MLJ
150129

RELEASED
09/07/08

C	REFORMAT DWG. -7 P/N NOW FLMN021-005-0000 WAS LNNM5S1 (ZN B8-1), PAR 09-020	CP	09.07.08
B	ADD D3015-7	KJ	03.07.15
A	NEW ISSUE	DS	01.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3015** REV. C
SHEET 1 OF 1
TITLE **LOCKNUT** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27306

Purchase Order Date 2/2/2015

PO Print Date 2/2/2015

Page Number 1 of 2

Order From :

VC-ACK001

ACKLANDS - GRAINGER INC.
P.O. BOX 2970
WINNIPEG, MB R3C 4B5
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 2739

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	PFS-LNNC14S AS PER DWG D3015 REV. C B128944	SS Locknut	2/4/2015 Yes 2/4/2015	FN	100.00 Each	\$0.09	\$9.00
Line Total:							\$9.00
2	FLMN021-005-000 AS PER DWG D3015 REV. C B128856	Locknut	2/4/2015 Yes 2/4/2015		100.00 Each	\$0.09	\$9.00
Line Total:							\$9.00
3	PFS-FW14S1 AS PER DWG D2529 REV. E B128950	WASHER	2/4/2015 Yes 2/4/2015		500.00 Each	\$0.06	\$29.65

Note:

2/2/2015

FORM 7889-1